

Work Order ID 128046

December-23-14 8:52:32 AM

128046

Page 1

Item ID: D3152-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 12/23/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/23/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference: rework

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3152	Rev B

100 0.00

100

Small Fab

Small Fab

Small Fab

Memo

pull from stk:

1 x D3152-041 B1053617

Bond D3152-3 Seal to D3152-1 Bracket using RTV 732 per Dwg D3152.RTV
 732 Batch: 0131036 Expiry: 16/12/11 Identify as
 D3152-041

14-12-23 11

110

QC5- Inspect part completeness to step on W/O 0.00

110

QC

Quality Control

Memo

0.00

14-12-23 PD

Work Order ID 128046

December-23-14 8:52:32 AM

128046

Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>CAZ</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging	re-identify using new b/n								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

14-12-23 (1)

MC5 14-12-24

14-12-23

Picklist Print

December-23-14 8:52:32 AM

Page 1

Work Order ID: 128046

128046

Parent Item: D3152-041

D3152-041

Parent Item Name: Bracket Assembly

Start Date: 12/23/14

Required Date: 12/23/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Removed Purchasing 05-12-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3152-041		Manufactured	No				Each	1.0000		1			
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D3152-041

Bracket Assembly

14-12-23

Location

Loc Qty

Loc Code

Mezz

1

25284

1

1053617



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3152	REV. B SHEET 1 OF 2
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING & RTV 732 BLACK	

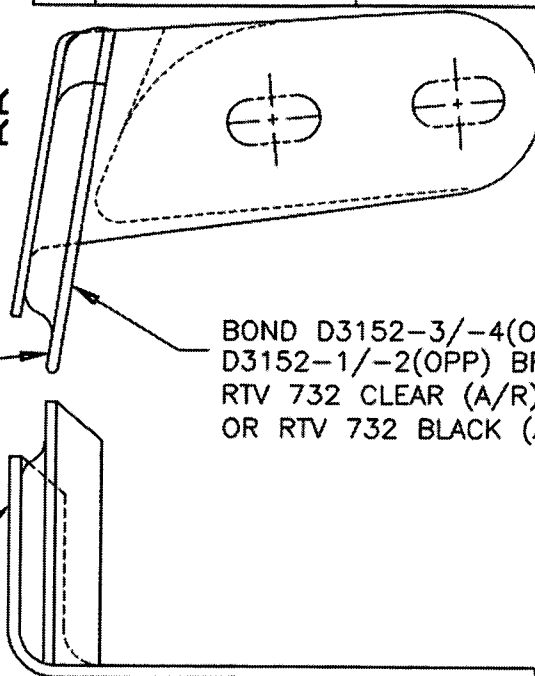
RELEASED
04-11-23

D3152-041 BRACKET ASSEMBLY
D3152-042 BRACKET ASSEMBLY

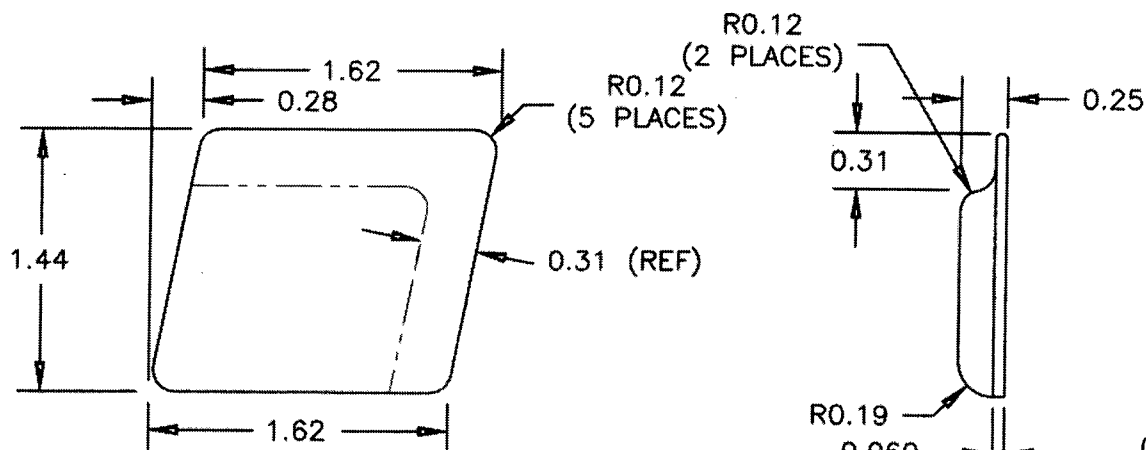
IDENTIFY WITH DART P/N
USING FINE POINT PERMANENT
INK MARKER

D3152-3 (-041)
or D3152-4 (-042)

D3152-1 (-041)
or D3152-2 (-042)





BOND D3152-3/-4(OPP) SEAL TO
D3152-1/-2(OPP) BRKT USING
RTV 732 CLEAR (A/R)
OR RTV 732 BLACK (A/R)



D3152-3 SEAL (SHOWN)
D3152-4 SEAL (OPPOSITE)

1. D3152-3 REPLACES PREMIER P/N B30-23000-243
D3152-4 REPLACES PREMIER P/N B30-23000-244
2. MAKE D3152-3 PER TOOL # B30-23000-243T
MAKE D3152-4 PER TOOL # B30-23000-244T
3. MATERIAL: RTV 732 BLACK
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES

60  

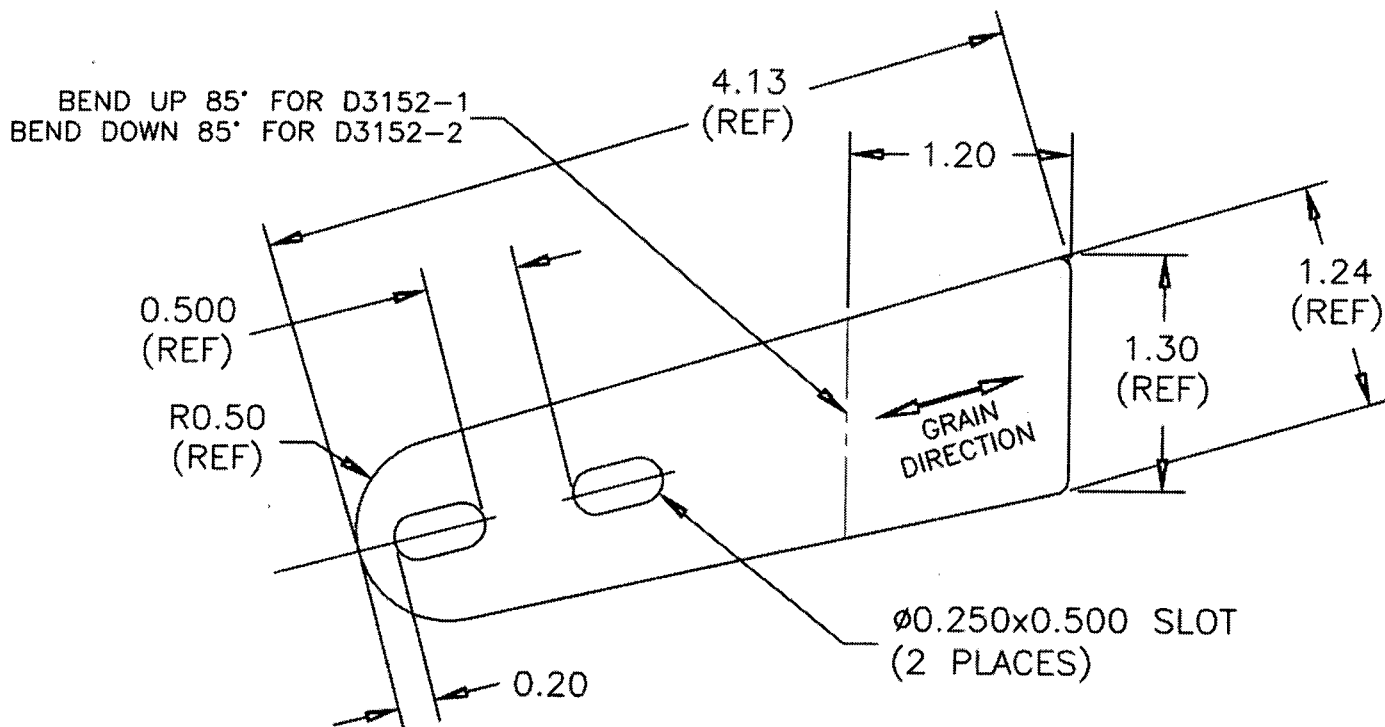
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3152	REV. B SHEET 2 OF 2
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.11.23



D3152-1/-2 BRACKET

1. D3152-1 REPLACES PREMIER P/N B30-23000-223
D3152-2 REPLACES PREMIER P/N B30-23000-224
2. MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF DART SPEC. M2024T3S.063)
3. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES
6. BREAK ALL SHARP EDGES 0.005 TO 0.010
7. MACHINE PER DWG FILE "D3152-B2.DWG"

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